

Date: Thursday, 20/11/2008 3:36:03 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ACCESS PANEL ASSEMBLY
<b>Job Number</b> : 43635	
<b>Estimate Number</b> : 13010	
<b>P.O. Number</b> :	<b>Part Number</b> : D3245043
<b>This Issue</b> : 20/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3245 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 42466	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 21/12/2008 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.11.21</u>	
<b>Comment</b> : Est Rev :A New Issue 07-09-11 JLM Verified By:EC Est Rev:b ECN 1052 07-10-31 DD verified by:	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0	D32453	Door
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Door  
 Batch: B42487

3.0	D32457	Gasket
-----	--------	--------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Gasket  
 Batch: B43769(38) B35668(1x)

4.0	235120009C3Y	STUD
-----	--------------	------



**Comment:** Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)  
 STUD  
 Batch: M106484

5.0	127H35	HALF GROMMET
-----	--------	--------------



**Comment:** Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)  
 HALF GROMMET  
 Batch: M109624

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 20/11/2008 3:36:03 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 43635

Part Number: D3245043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Studs and Gromets as per Dwg D3245

3-Bond Gasket using 3M ADHESIVE as per Dwg D3245

A/R 3M 1300/1300L ADHESIVE

Batch: *M1109410*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P# and B# using fine point permanent ink marker and Stock

Location: *Store*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF*

*09-03-03*

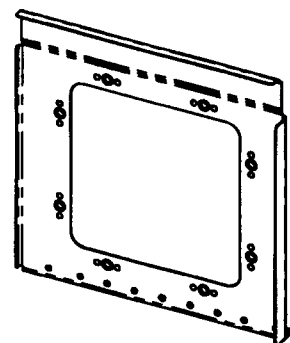
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

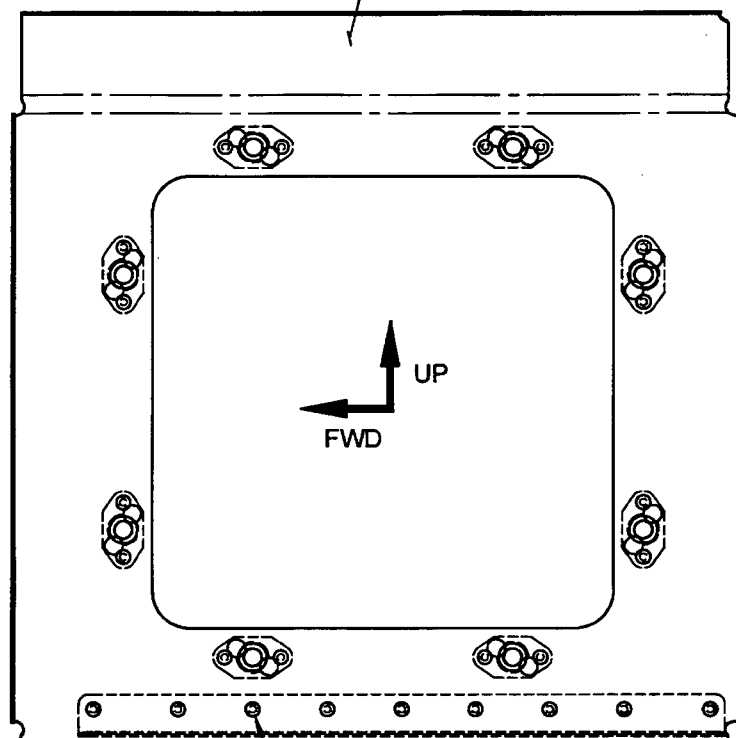
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D3245-1  
PANEL

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)



MS20615M3-3 RIVET  
(9 PLACES)

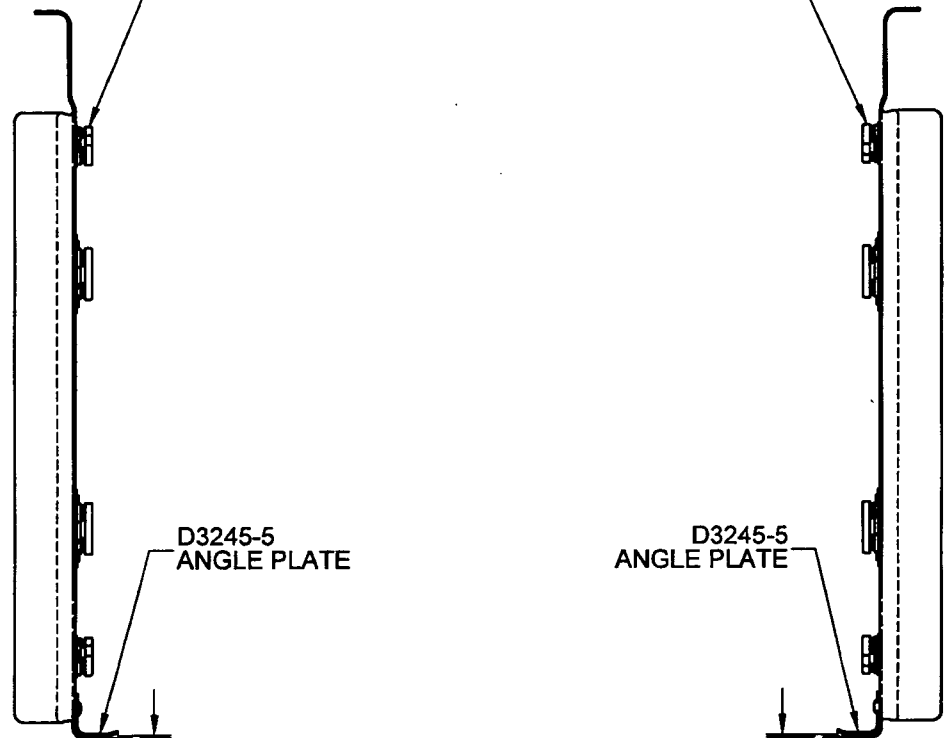
**D3245-041 ACCESS PANEL ASSEMBLY**

**RELEASED**  
07-10-23

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER  
7) WEIGHT: 0.83 lbs

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

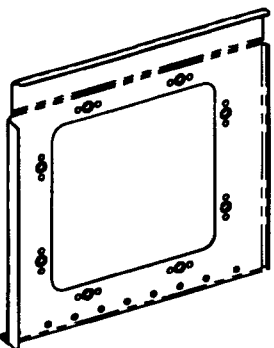


D3245-5  
ANGLE PLATE

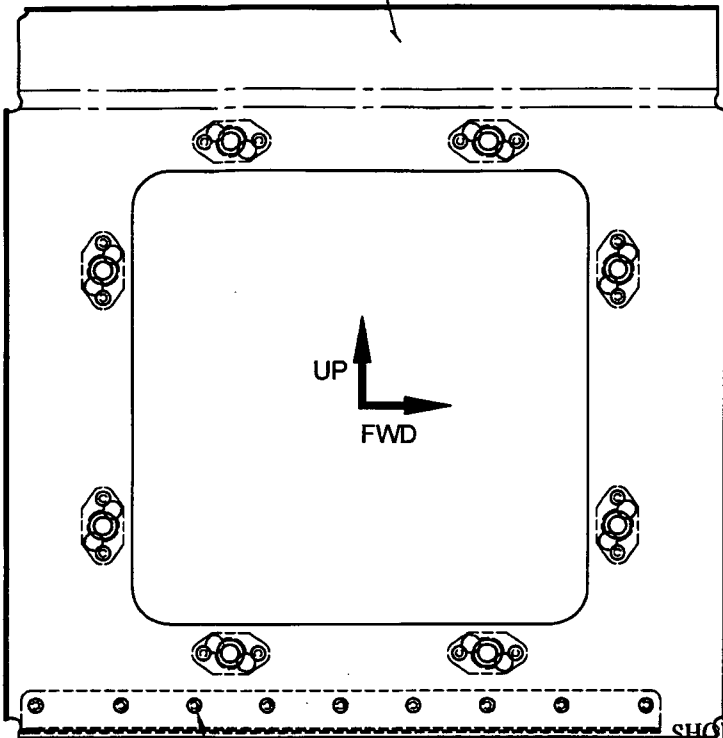
0.032  
GAP

D3245-5  
ANGLE PLATE

0.032  
GAP



D3245-2  
PANEL

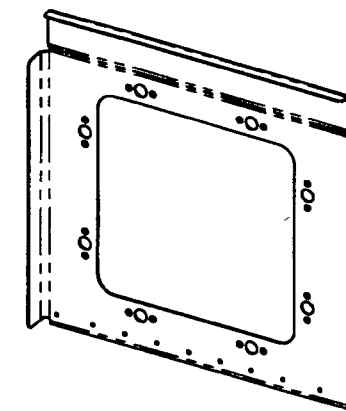
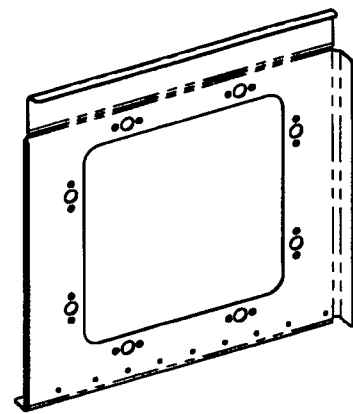


MS20615M3-3 RIVET  
(9 PLACES)

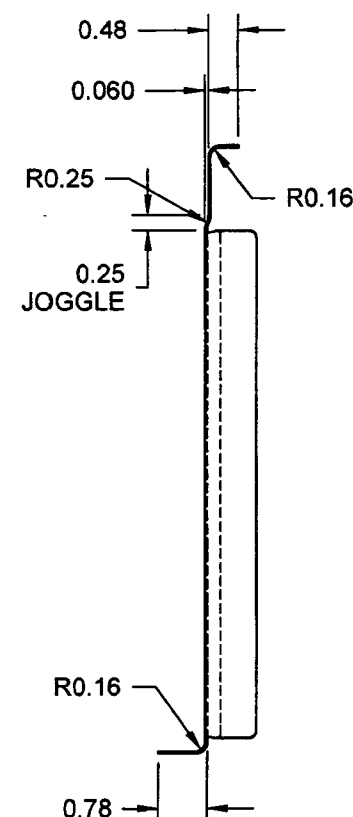
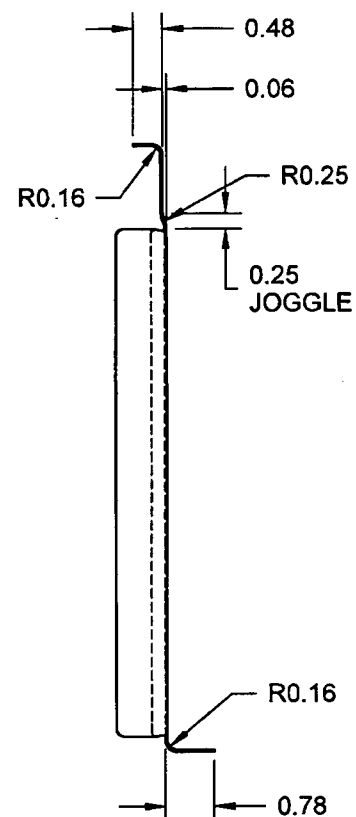
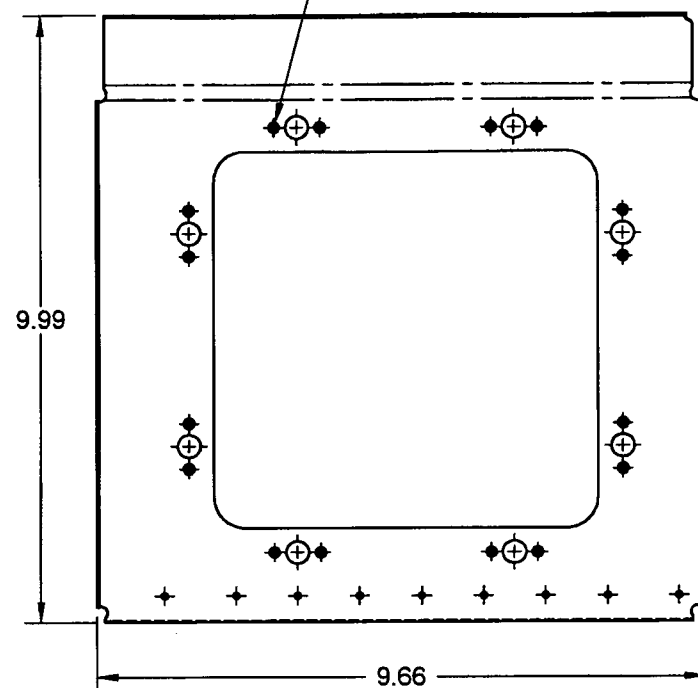
**D3245-042 ACCESS PANEL ASSEMBLY**

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4363

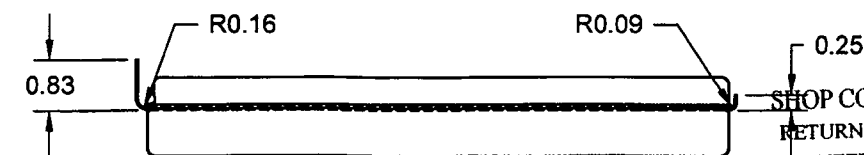
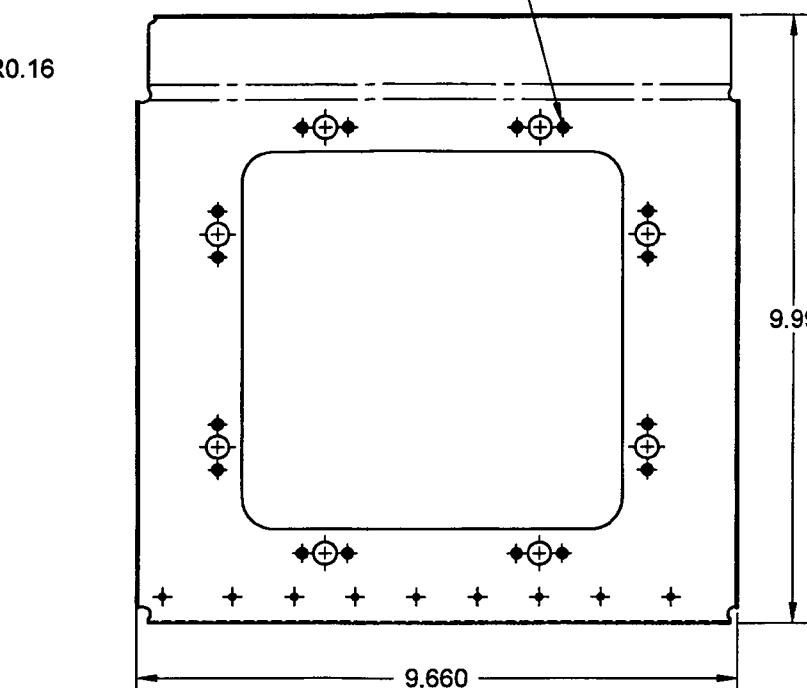
B	REMOVE Ø0.204 HOLES FROM D3245-1/-1F, REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042: HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO.	REV. B
CHECKED	PH	D3245	SHEET 1 OF 7
MFG. APPR.	DS	TITLE	SCALE
APPROVED	PH	ACCESS PANEL ASSEMBLY	1:2.5
DE APPR.	PH	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.10.02		



C'SINK  $\varnothing 0.170 \times 100^\circ$   
(16 PLACES)



C'SINK  $\varnothing 0.170 \times 100^\circ$   
(16 PLACES)



**D3245-1 PANEL BEND DETAIL, LH**

**D3245-2 PANEL BEND DETAIL, RH**

**RELEASED**  
07.10.23

**NOTES:**

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

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WORK ORDER  
NO. 43635

DESIGN	<del>7F</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>B</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DS	D3245	SHEET 2 OF 7
APPROVED	AD	TITLE	SCALE
DE APPR.	<del>SH</del>	ACCESS PANEL ASSEMBLY	1:3
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

D3245-5 DOOR

2351-20-009-C3Y STUD (1)  
127H-35 GROMMET (1)  
(8 PLACES)

D3245-7 GASKET  
(REF)

8.00  
(TYP, REF)

**D3245-043 DOOR ASSEMBLY**







INSTALL D3245-7   
GASKET ON THIS SIDE

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

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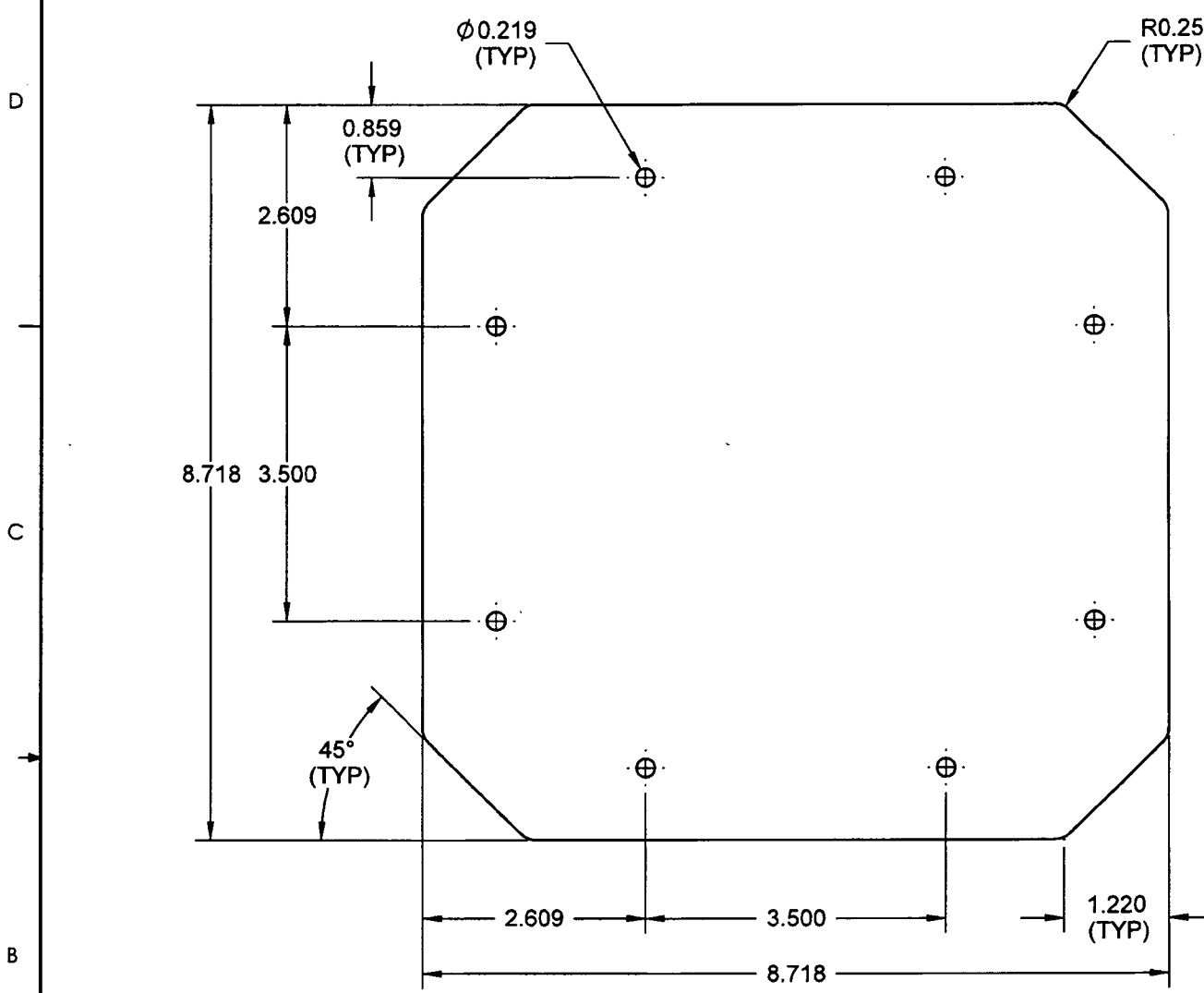
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3245</b>	REV. B
MFG. APPR.			SHEET 3 OF 7
APPROVED		TITLE <b>ACCESS PANEL ASSEMBLY</b>	SCALE 1:2
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	<b>07.10.02</b>		

**RELEASED**  
 07-10-23

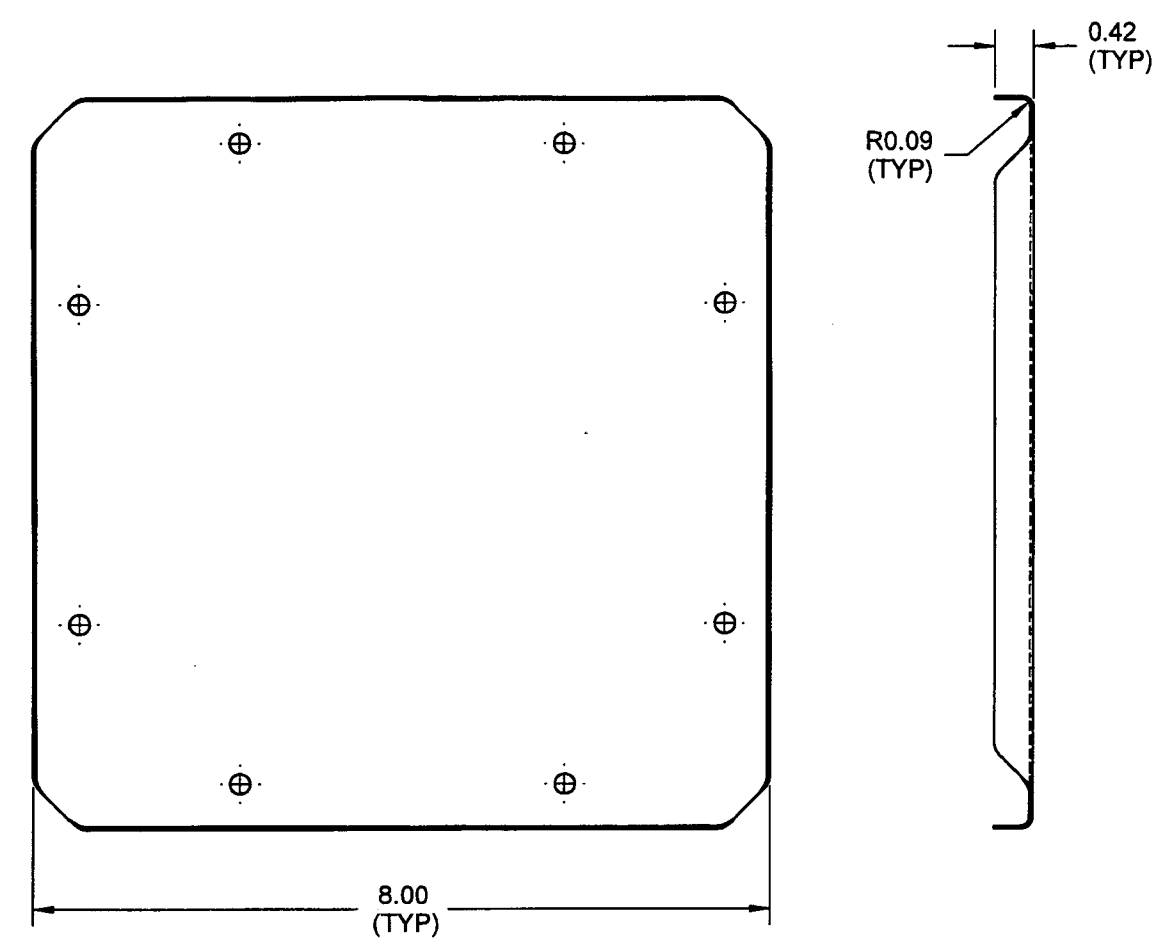




8 7 6 5 4 3 2 1



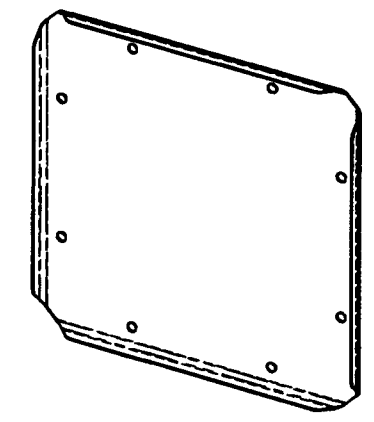
**D3245-3F DOOR FLAT PATTERN**



**D3245-3 DOOR BENDING DETAIL**

**RELEASED**  
07-10-03

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.67 lbs



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DESIGN	JH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JH	DRAWING NO.	REV. B
CHECKED	PH	D3245	SHEET 5 OF 7
MFG. APPR.	DS	TITLE	SCALE
APPROVED	JH	ACCESS PANEL ASSEMBLY	1:2
DE APPR.	JH	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.10.02		

8 7 6 5 4 3 2 1

D

D

C

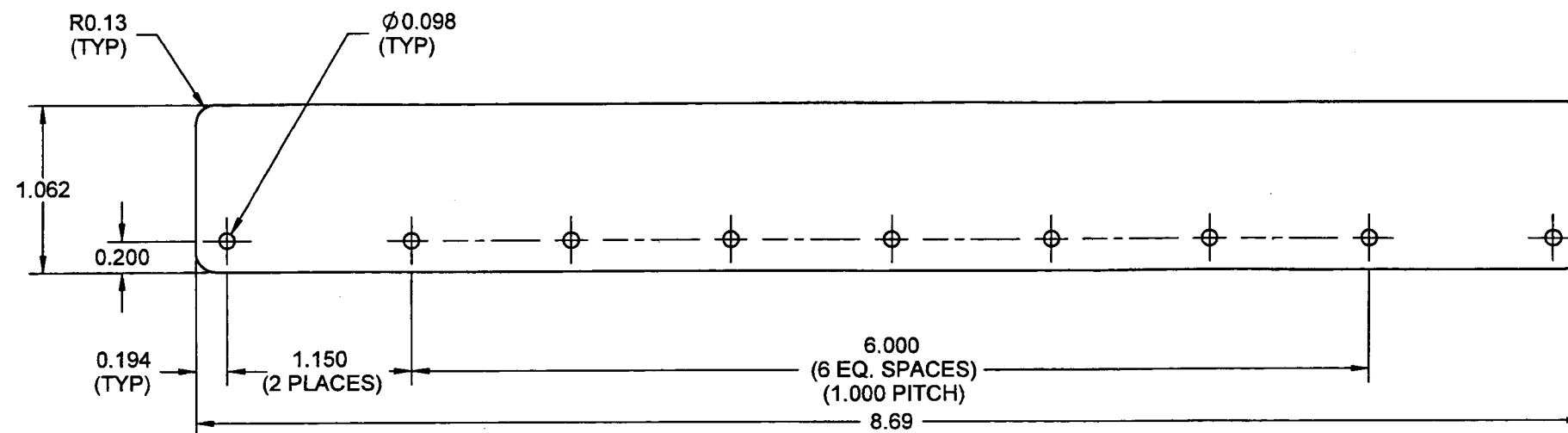
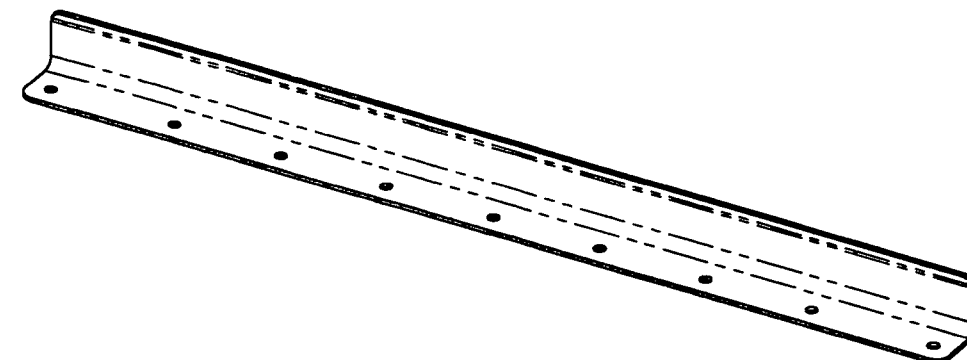
C

B

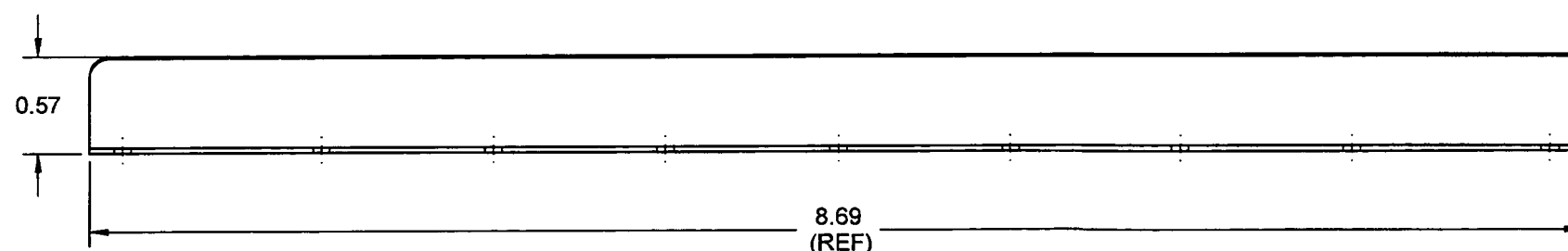
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A

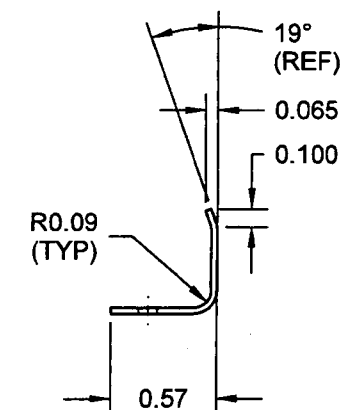
A



**D3245-5F FLAT PATTERN**



**D3245-5 BEND DETAIL  
(MAKE FROM D3245-5F)**



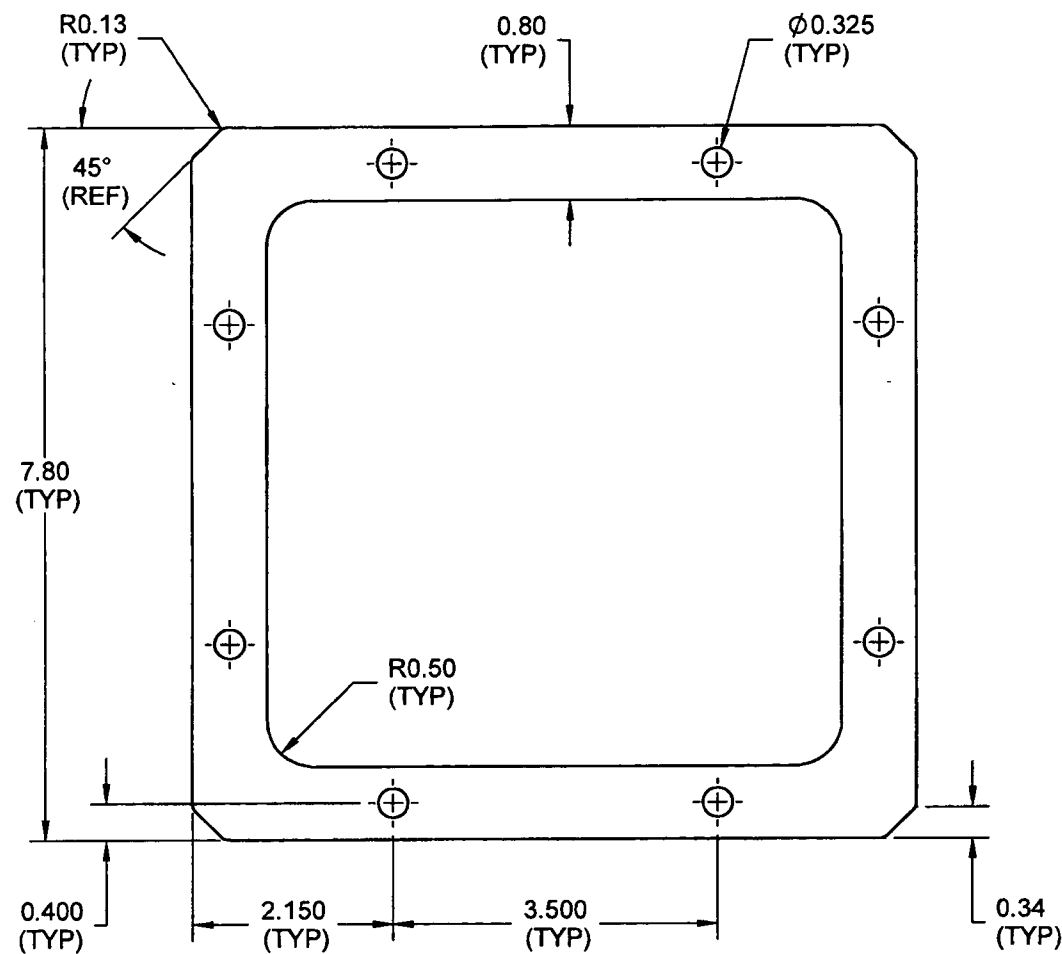
**RELEASED**  
07.10.23

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WORK ORDER  
NO. 43635

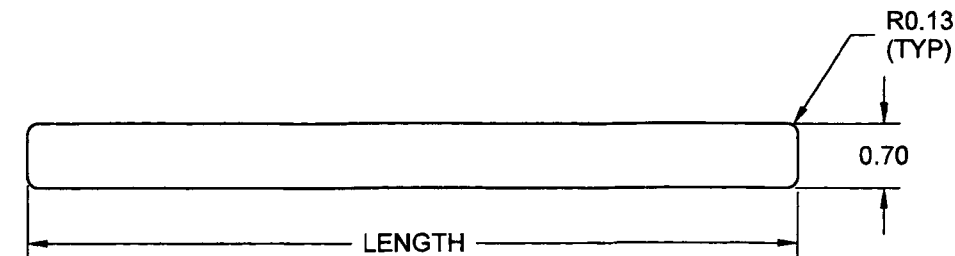
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.08 lbs

DESIGN	<del>TH</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>B</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DS	D3245	SHEET 6 OF 7
APPROVED	140	TITLE	SCALE
DE APPR.	<del>TH</del>	ACCESS PANEL ASSEMBLY	1:1
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8 7 6 5 4 3 2 1



**D3245-7 GASKET**



**D3245-X GASKET**

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

**RELEASED**  
07.10.03

- NOTES:**
- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK (PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A

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WITHOUT NOTICE  
WORK ORDER  
NO. 43635

DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DS</i>	DRAWING NO. <b>D3245</b>	REV. B
MFG. APPR.	<i>PH</i>		SHEET 7 OF 7
APPROVED	<i>PH</i>	TITLE <b>ACCESS PANEL ASSEMBLY</b>	SCALE 1:2
DE APPR.	<i>PH</i>		
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